

Work Order ID 59910

June 17, 2010 7:55:50 AM



Page 1

Item ID: D3284-001

Accept



Setup Start



Revision ID:

Stop



Item Name: Sleeve

Start Date: 6/17/10 Start Qty: 6.00



Cust Item ID:

Required Date: 6/18/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 10/6/17 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3284	Rev A								

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 12103 to Northern Aero Industries ☐ Order P/N: B80702-
1 ☐ Manufacture per B80702 Rev. A ☐ Certificate of Conformity is required

CL 10/6/17 (6)

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

Pd 10/9/21 (6)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Visually inspect parts for thread damage, fit and cad plating

Soloobi

(+6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59910

June 17, 2010 7:55:50 AM



Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: <u>ST044</u>	0.00							
Packaging	Memo	0.00							
Packaging									
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

6/17/10 (6)

10/06/21

MF 10-6-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 17, 2010 7:55:49 AM

Work Order ID: 59910

Parent Item: D3284-001

Parent Item Name: Sleeve




Start Date: 6/17/10

Required Date: 6/18/10

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP B 04.10.21 Added Step 4 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
B80702-1  Sleeve		Purchased	No			110	Each	0.0000	1	6			

PU 6/21/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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SPECIFICATION CONTROL DRAWING

DART P/N	SPECIFICATION
D3284-001 SLEEVE	ACS P/N B80702-1 PER ACS DWG B80702 REV. A
D3284-003 STUD	ACS P/N B80703-1 PER ACS DWG B80703 REV. A
D3284-005 STUD	ACS P/N B80704-1 PER ACS DWG B80704 REV. A
D3284-007 STUD	ACS P/N B80705-1 PER ACS DWG B80705 REV. B
D3284-009 BEARING	BHT P/N 47-140-252-5
D3284-011 BEARING	BHT P/N 205-060-101-001
D3284-021 TUBE ASSY	204-060-158-001 MODIFIED PER IIN-D205-708
D3284-023 BIPOD ASSY	204-060-155-001 MODIFIED PER IIN-D205-708
D3284-025 TRIPOD ASSY	204-060-157-001 MODIFIED PER IIN-D205-708
D3284-031 TUBE ASSY	205-060-107-001 MODIFIED PER IIN-D205-708
D3284-033 BIPOD ASSY	205-060-106-001 MODIFIED PER IIN-D205-708
D3284-035 TRIPOD ASSY	205-060-105-001 MODIFIED PER IIN-D205-708



NOTE:

FOR FUTURE PROCUREMENT, THE PURCHASE ORDER MUST SPECIFY THAT THE MATERIAL USED TO MANUFACTURE THE D3284-001/-003/-005/-007 PARTS MUST COMPLY WITH THE FOLLOWING SPECIFICATIONS:

AISI 4130 ROUND BAR PER AMS 6348/MIL-S-6758 WITH
 MIN Ft_u = 90 Ksi
 MIN Ft_y = 70 Ksi

EACH INDIVIDUAL ITEM TESTED BEFORE USE OR PROVEN TO EQUAL OR EXCEED THE ABOVE.

C21016117

W10: 59910

RELEASED

2010-03-25

B	ADD NOTE	RF	09.07.14
A	NEW ISSUE	KJ	04.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3284	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		ADJUSTABLE ENGINE MOUNT	NTS
DATE	09.07.14	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO12103**

Purchase Order Date 6/17/10

PO Print Date 6/17/10

Page Number 1 of 1

Order From :

VU-NOR003

NORTHERN AERO INDUSTRIES LTD.
25 DUNLOP AVENUE
WINNIPEG, MB R2X 2V2
CA

*e-mail
maeci*

Contact Name

Vendor Phone

204-772-9922

Vendor Fax

204772-7568

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

USD

FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	B80702-1	Sleeve	6/18/10 Yes	6.00 Each	FedEx PI ppd	\$117.0000	\$702.00

Special Inst: AS PER DWG D3284 REV. A
B59910
ACS P/N: B80702-1 PER ACS DWG
B80702 REV.A

PO Total:

\$702.00

**CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY**

Change Nbr: 1

Change Date: 6/17/10

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

ACS-NAI

Engineering, Certification & Manufacturing

25 Dunlop Ave
Winnipeg, Manitoba, Canada, R2X 2V2
Ph: 204-772-9922 Fax: 204-772-7568

CERTIFICATE OF CONFORMITY

Form Tracking No.23066-1		Work Order/Contract/Invoice PO: 12103		Cage Code: MFR L0555	
Item 1	Description Sleeve	Part No. B80702-1	Quantity 6	Serial/Batch 08-1874	Status manufactured
5 10/6/10					

Remarks:

THESE ITEMS CONFORM TO DESIGN DATA B80701 (REV. C).

DETAILS OF THE WORK PERFORMED ARE RECORDED ON ACS-NAI WORK ORDER # WO18601.

New-Unused Parts/Material Certification

The items described above have been manufactured using standards employed by a TCCA approved manufacturer in accordance with CAR 561 and a AS9100 Quality Assurance System.

Signature

Name R. D. WILLIAMSON

Date (dd mmm yyyy)
17 JUN 10~~Used, Repaired or Overhauled Parts Certification~~~~The items described above have been maintained using standards employed by a TCCA approved maintenance organization in accordance with CAR 573 and a AS9100 Quality Assurance System.~~~~Signature~~~~Name~~~~Date (dd mmm yyyy)~~

User/Installer Responsibilities: This certificate does not constitute authority to install the item(s) described above on an in-service type certified aircraft.

ACS-NAI Ltd.

25 Dunlop Avenue
R2X 2V2 Winnipeg
Canada
Tel : 204-772-9922
Fax : 204-772-7568

Delivery No. : 993
Delivery Date : 06/17/2010
SO No. : 23066
Your Reference : PO: 12103
Delivery Method : FEDEX ACCT# 2351 4353 4
Payment Condition : Net 30 Days

Delivery to: Dart Aerospace Ltd.

Attention:Accounts
1270 Aberdeen Street

Hawkesbury K6A 1K7
Canada

Item	Description Batch Number	Total Ordered	Unit	Qty Delivered	Delivery Date
B80702-1	SLEEVE 08-1874	6	EA	6	06/18/2010

CURRENCY: US FUNDS
SHIP VIA: FEDEX ACCT# 151793240
ORDERED BY: CHANTAL LAVOIE @ 613-632-9577
TAX RESALE # 10127-2607

*S
10/06/10*

Packages: 0

Gross Weight: 0.00

Net Weight:

Ordered by: Dart Aerospace Ltd.

Attention: Accounts
1270 Aberdeen Street

Hawkesbury K6A 1K7
Canada

Invoice to: Dart Aerospace Ltd.

Attention: Accounts
1270 Aberdeen Street

Hawkesbury K6A 1K7
Canada

0.00

Remarks**Certification Statement**

I hereby certify that the aircraft part(s) described hereon were acquired from a source of supply that is consistent with the conditions under which TCCA distributor approval AMO88-97 has been granted.

Signatory

Date: